



# **DOUGLAS FIR<sup>\*</sup>** **PLYWOOD** **GRADE** **INFORMATION**

**FROM U. S. COMMERCIAL STANDARD CS45-55**

**DESCRIPTION**—Douglas fir plywood consists of an odd number of thin sheets of wood (veneers) bonded together so that the grain direction of each ply is at right angles to the next.

**TYPES**—Douglas fir plywood comes in two types: *Exterior* and *Interior*. Exterior-type plywood is manufactured with glue that is completely waterproof and weather-proof. The glue is actually stronger and more durable than the wood itself. Interior plywood is made with highly moisture-resistant (not waterproof) glues.

**GRADES**—Within each *type* there are several appearance grades. Grade is determined by the appearance quality of the veneer used for the face and back of the panel. Principal veneer qualities are shown on inside. These are A, B, C, and D. In addition, N (Natural Finish) veneer is used in two special order Interior items: N-D and N-N. (See back page).

**TESTED-QUALITY**—DFPA grade-trademarks provide identification of both type and grade. They are positive assurance of plywood manufactured, inspected and DFPA quality-tested in accordance with the exacting requirements of U. S. Commercial Standard CS45-55.



\* West Coast plywood manufacturers also produce panels of other Western softwoods in types and grades comparable to Douglas fir plywood. These plywoods are DFPA-tested and grade-trademarked in accordance with U. S. Commercial Standard CS 122-56.

**DOUGLAS FIR PLYWOOD ASSOCIATION**  
**TACOMA 2, WASHINGTON**





# **veneer** **qualities**

**USED IN DOUGLAS FIR PLYWOOD**

## **veneer quality**

## **defect limitation**

**A**

Presents smooth surface. Free from knots, open splits, pitch-pockets and other open defects.

Veneer shall be well joined if more than one piece is used.

Admits discoloration, sapwood and pitch streaks, averaging not more than 3/8" width and blending with color of wood.

Admits maximum of 18 veneer patches in 4' x 8' sheet.

Admits shims and neatly made panel patches.

Shims may not be used over or around any type of patch and multiple repairs must be limited to TWO patches.

All patches and repairs to run parallel to the grain.

Admits approved plastic filler in splits and other minor defects up to 1/32" in width; in small splits or openings up to 1/16" in width if not more than 2" long; in small chipped areas or openings not to exceed 1/8" wide by 1/4" long.

**B**

Presents solid surface. Free from open defects except splits not wider than 1/32".

Vertical ambrosia beetle borer holes permitted if not exceeding 1/16" in diameter and averaging not more than 1 per sq. ft.; and also horizontal tunnels 1/16" across, 1" length, 12 in number in 4' x 8' panel, or proportionately in other dimensions.

**C**

**REPAIRED**

For Underlayment grade only. Tight knots up to 1 1/2" in greatest dimension and worm and borer holes or other open defects not to exceed 1/4" and 1/2" allowed.

Splits—not to exceed 1/16" wide allowed.

Solid, tight pitch-pockets, ruptured and torn grain, minor sanding defects and sander skips up to 5% of panel area admitted.

**C**

Knotholes—1" in least dimension. Pitch-pockets—not wider than 1". Splits—3/16" (must taper to point).

Worm or borer holes 5/8" x 1 1/2".

Tight knots—1 1/2".

Plugs, patches, shims and minor sanding defects admitted.

**D**

D veneer used only in Interior-type plywood. Knotholes—2 1/2". Pitch-pockets—2" x 4".

Splits, widths at widest point—

1/2" up to quarter panel length.

1/4" up to half panel length.

3/16" up to full panel length.

All must taper to point.

Plugs, patches, shims, worm or borer holes and minor sanding defects admitted.

**N**

**NATURAL FINISH**

(see back page)

Special grade. Presents smooth surface. 100% heartwood of yellow or pink color without stain.

Free from knots, splits, pitch-pockets and other open defects.

If joined, not more than three pieces of veneer shall be used, joints to be well matched as to color and grain, all joints to be parallel to the edges of the panel.

Maximum of 2 shims allowed, not to exceed 6" long at end of panel.

Maximum of 4 well matched small patches not to exceed 3/8" x 2 1/2" admitted.







All repairs to be parallel to the grain of the panel; neither over-lapping of repairs nor plastic filled is permitted,



# EXTERIOR-TYPE 100% WATERPROOF GLUE FOR OUTDOOR AND MARINE USES

		Veneer Quality*			Standard Stock Sizes†									
GRADE-TRADEMARK	TYPICAL USES	FACE	BACK	INNER PLYS	Width Ft.	Lgth. Ft.	THICKNESS (inches) ‡							
							¼	⅝	¾	½	⅜	¼	1	
① EXT-DFPA·A-A	Use where appearance of both sides is important. Fences, carport enclosures, signs, boats, etc.	A	A	C	4	8	x		x	x	x	x	x	
① EXT-DFPA·A-B	Alternate for A-A grade where appearance of one side is less important.	A	B	C	4	8	x		x	x	x	x	x	
EXT-DFPA PLYSHIELD®	Use where appearance of one side only is important such as siding, soffits, fences, store fronts and other exterior uses.	A	C	C	4	8	x		x	x	x	x	x	
① EXT-DFPA·UTILITY·B-C	Utility outdoor building panel. Farm buildings, etc.	B	C	C	4	8	x		x	x	x	x		
EXT-DFPA·UNDERLAYMENT	Base for tile, linoleum, etc., where unusual moisture conditions exist.	C (Rep'd)	C	C	4	8	x		x	x	x	x		
EXT-DFPA·SHEATHING·C-C	Unsanded construction panel with waterproof bond.	C	C	C	4	8		x	x	x	x	x		
EXT-DFPA PLYFORM®	Concrete form grade, maximum re-use. Can be re-used until wood is literally worn away. Edge sealed with distinctive red sealer. Mill oiled unless otherwise specified.	B	B	C	4	8						x	x	

# INTERIOR-TYPE MOISTURE-RESISTANT GLUE FOR INDOOR AND STRUCTURAL USES

		Veneer Quality*			Standard Stock Sizes†							
GRADE-TRADEMARK	TYPICAL USES	FACE	BACK	INNER PLYS	Width Ft.	Lgth. Ft.	THICKNESS (inches) ‡					
							1/4	5/16	3/8	1/2	5/8	3/4
① <b>INTERIOR · A · A · DFPA</b>	Use indoors where both sides to be in view. Cabinet doors, built-ins, furniture.	A	A	D	3-4	8	x		x	x	x	x
① <b>INTERIOR · A · B · DFPA</b>	Alternate for A-A. For uses requiring one surface highest appearance, opposite side solid and smooth.	A	B	D	3-4	8	x		x	x	x	x
<b>PLY PANEL</b> 	For interior use where high appearance of only one side is important such as paneling, built-ins, backing and underlayment.	A	D	D	3-4	8	x		x	x	x	x
① <b>INTERIOR · B · D · DFPA</b>	Utility panel for uses requiring one smooth, solid side. Backing, cabinet sides, etc.	B	D	D	4	8	x		x	x	x	x
<b>PLY BASE</b> 	Underlayment grade. Base for tile, linoleum, carpeting.	C (Rep'd)	D	C § D	4	8	x		x	x	x	x
<b>PLYSKORD</b> 	Unsanded sheathing or structural grade. For sheathing, subflooring, etc., barricades.	C	D	D	4	8		x	x	x	x	x
<b>PLYSKORD</b> ® <b>EXTERIOR GLUE</b> 	Unsanded structural grade panel with waterproof glue line. For sheathing, subfloor, etc.	C	D	D	4	8		x	x	x	x	x
<b>INTERIOR PLYFORM</b> 	Re-usable concrete form plywood. Edge sealed with distinctive green sealer. Mill oiled unless otherwise specified.	B	B	C	4	8					x	x
	New combination subfloor and underlayment base for tile, linoleum, carpeting and wood strip flooring. Used on 4 foot span grid system.	C (Rep'd)	D	D	4	8					1 1/8" only	

\*All grades sanded both sides except EXT-DFPA Sheathings and Interior PlyScord.

†OTHER SIZES than those shown in tables are standard but not normally stocked. About three-quarters of all fir plywood comes in 4'x8' sheets; 1/4" to 3/4" thicknesses are most popular. King-size panels (12', 14', 16', 20' and longer) are also available.

‡Panels 3/8" and thinner, have minimum of 3 plys; 1/2" to 3/4" inclusive are 5-ply minimum; thicker panels have 7-ply minimum.

§Veneer next to face is C or better.



# SPECIALTY PLYWOOD

SPECIAL PANEL PRODUCTS OF THE FIR PLYWOOD INDUSTRY,  
PRODUCED UNDER THE DFPA QUALITY-CONTROL PROGRAM

	Name	Description	Uses	Standard Stock Sizes*		
				Width	Length	Thickness
<b>Special Surface Patterns</b>	<b>Texture® One-Eleven</b>	Exterior plywood with pattern of deep parallel grooves, slightly rough, (unsanded). Grooves ¼" deep, ⅜" wide. Edges shiplapped. EXT-DFPA®.	Siding, gable ends, patio fences, interior paneling. Ceilings; displays.	16" (grooves 2" o.c.) 32" & 48" (grooves 4" o.c.)	8' 10'	5/8"
	<b>Brushed Embossed and Striated Plywood</b>	Wood grain of panel face accented to create depth and dimension. Both Exterior and Interior types.	Paneling, built-ins, counter facing, displays, etc. Gable ends, siding (Exterior-type only).	4'	8'	3/8" 5/16"
<b>Overlaid Panels</b>	<b>Medium-density Overlaid Plywood</b>	Exterior plywood (EXT-DFPA) with smooth, fused-resin fiber overlay. Highly paintable, durable. Overlay is opaque, blanks out grain.	Exterior siding, soffits, etc. Kitchen cabinets, signs.	4'; also pre-cut to 12", 16" & 24" siding widths	8'	3/8", 1/2" 5/8", 3/4"
	<b>High-density Overlaid Plywood</b>	Exterior plywood (EXT-DFPA) with hard, glossy overlay. Durable, paintable. Abrasion-resistant. Overlay is translucent.	Concrete form work, signs, cabinets. Many industrial uses.	4'	8'	3/8", 1/2" 5/8", 3/4"
	<b>Plyron®</b>	Hardboard faced plywood. Comes in both Exterior (EXT-DFPA) and Interior types.	Cabinet doors, wardrobes, built-ins. Counter tops, shelving. Concrete form work.	4'	8'	1/2", 5/8" 3/4"
<b>Special Items</b>	<b>Natural Finish</b> Ⓢ INTERIOR · N-D · DFPA Ⓢ INTERIOR · N-N · DFPA	Cabinet-quality panels, one or both sides select, all heartwood veneer. For natural or stain finishes. Interior only. Special solid core construction.	Cabinet doors, paneling, built-ins. Furniture to be given natural finish.	4'	8'	N-D 1/4" N-N 3/4"
	<b>Marine Exterior</b> Ⓢ ⚓ MARINE · EXT-DFPA · ⚓	Exterior-type (EXT-DFPA) panels in grades A-A, A-B, B-B or special overlays and with special core construction for marine use.	Boat hulls, cabins, etc.	Available in standard sizes and thicknesses, also long lengths.		

\*Other sizes than shown are available but are not normally stocked.

## DFPA Grade-trademarks are your Assurance of Quality Plywood



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